

# Work Order ID 88514

August-02-12 11:35:03 AM

**\*88514\***

Page 1

Item ID: D3574-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Cabin Floor Protector

Start Date: 7/27/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/08/13

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

1 0 Jm 12-8-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

1 0 Jm 12-8-24

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

5MB  
12-8-24 DAS  
16 12/08/13

1

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																								
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced. <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	88514
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-5
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003"	✓		✓	
7.37	+/-0.030	7.375"	✓		✓	
11.00	+/-0.030	11.008"	✓		✓	Produced
15.25	+/-0.030	15.25"	✓		T	H301
25.87	+/-0.030	25.87"	✓		T	
39.75	+/-0.030	39.75"	✓		T	
44.75	+/-0.030	44.75"	✓		T	
49.11	+/-0.030	49.11"	✓		T	
51.11	+/-0.030	51.11"	✓		T	
1.75	+/-0.030	1.754"	✓		IV	mmol
58.38	+/-0.030	58.38"	✓		T	
63.50	+/-0.030	63.50"	✓		T	
65.25	+/-0.030	65.25"	✓		T	
11.87	+/-0.030	11.875"	✓		✓	
14.75	+/-0.030	14.75"	✓		✓	
26.00	+/-0.030	26.00"	✓		T	
40.87	+/-0.030	40.87"	✓		T	
45.00	+/-0.030	45.00"	✓		T	
48.00	+/-0.030	48.00"	✓		T	
55.13	+/-0.030	55.13"	✓		T	
58.38	+/-0.030	58.38"	✓		T	
61.25	+/-0.030	61.25"	✓		T	
61.88	+/-0.030	61.88"	✓		T	
64.63	+/-0.030	64.63"	✓		T	
7.63	+/-0.030	7.633"	✓		✓	
11.00	+/-0.030	11.012"	✓		✓	
22.50	+/-0.030	22.50"	✓		T	
35.13	+/-0.030	35.13"	✓		T	
36.50	+/-0.030	36.50"	✓		T	
40.00	+/-0.030	40.00"	✓		T	
41.88	+/-0.030	41.88"	✓		T	
43.63	+/-0.030	43.63"	✓		T	
6.75	+/-0.030	6.759"	✓		✓	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	88574
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-5
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 2 of 2</b>	

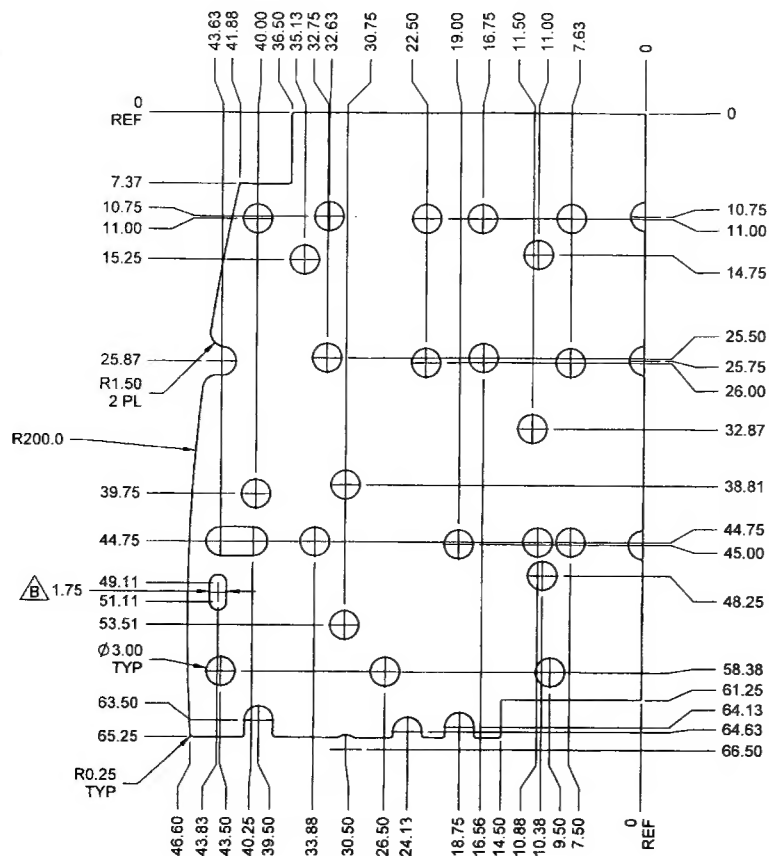
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.50"	✓		✓	
10.38	+/-0.030	10.38"	✓		✓	
14.50	+/-0.030	14.50"	✓		T	
16.75	+/-0.030	16.75"	✓		T	
19.00	+/-0.030	19.00"	✓		T	
24.13	+/-0.030	24.13"	✓		T	
33.88	+/-0.030	33.88"	✓		T	
39.50	+/-0.030	39.50"	✓		T	
40.25	+/-0.030	40.25"	✓		T	
43.50	+/-0.030	43.50"	✓		T	
43.83	+/-0.030	43.83"	✓		T	
46.60	+/-0.030	46.60"	✓		T	
0.125	+/-0.010	0.125"	✓		✓	

<b>Measured by:</b> Jm	<b>Audited by:</b> Smb	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-8-24	<b>Date:</b> 12-8-24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

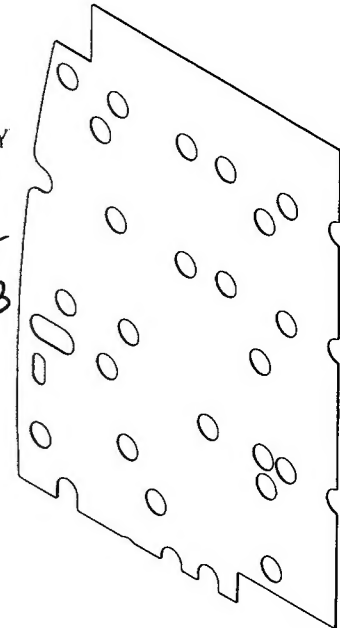


**D3574-1 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

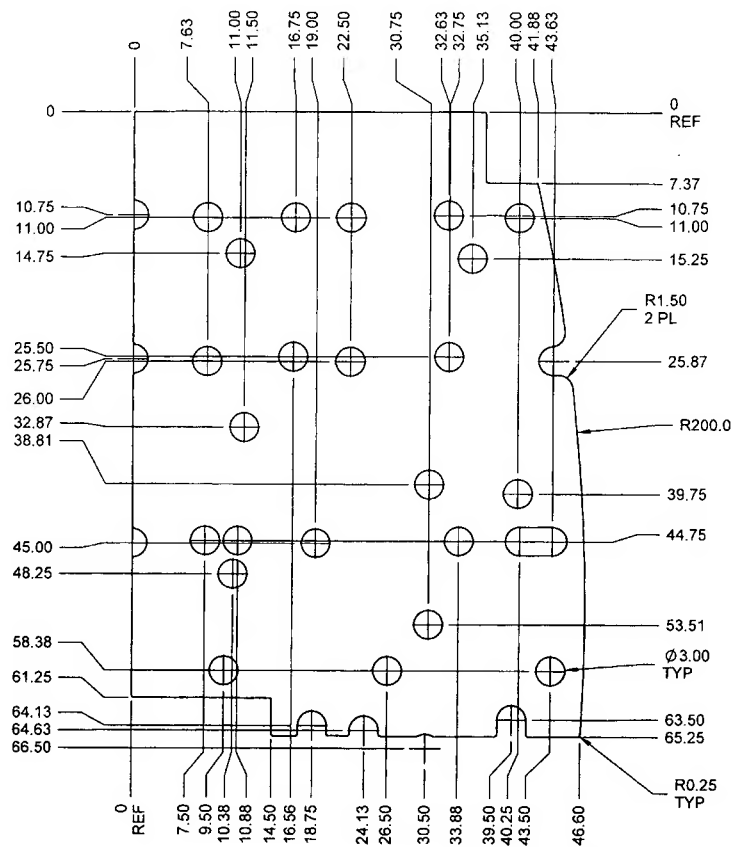
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WITHOUT NOTICE  
WORK ORDER  
NO. 88514 MLJ  
12/08/13



**RELEASED**  
01/07/07

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	
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REV. B		SHEET 1 OF 6
SCALE		NTS

88514

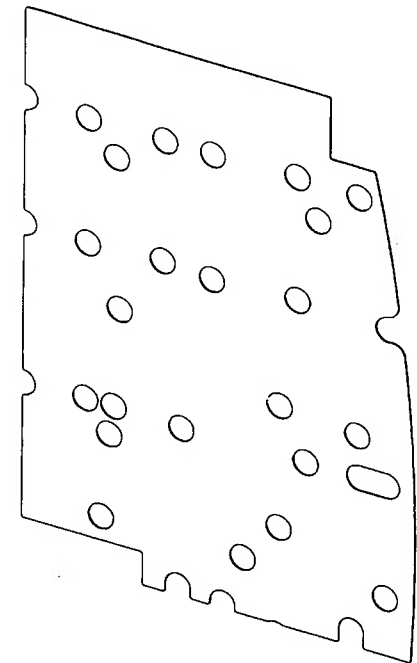


**D3574-2 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXX.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

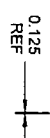
0.125  
REF



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09/04/01 JMD

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MFG. APPR.		<b>D3574</b>	SHEET 2 OF 6
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2/24/07

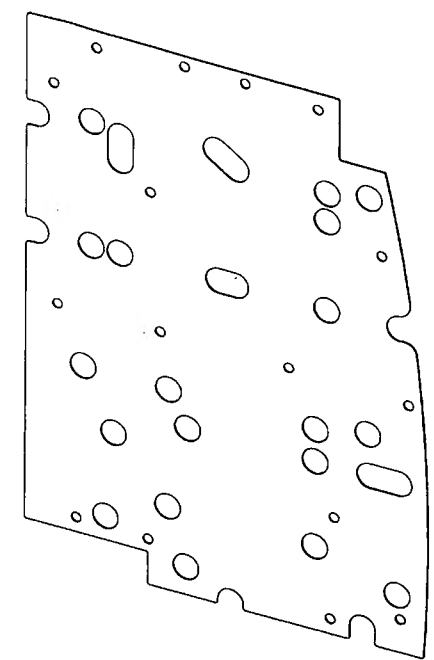
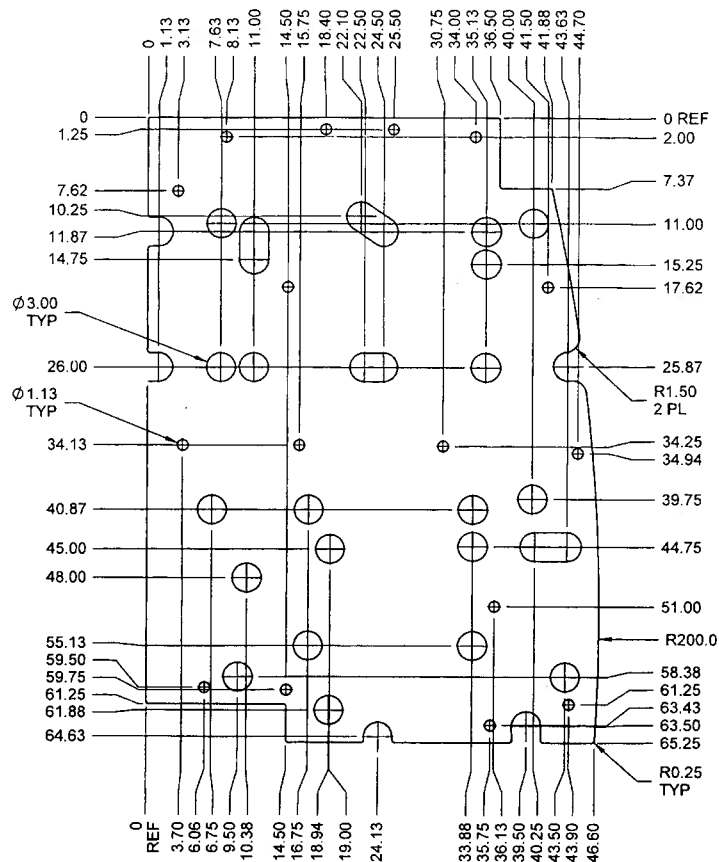


**D3574-3 CABIN FLOOR PROTECTOR**

- NOTES:  
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MILEX: 1254-F60029-04)  
2) FINISH: N/A  
3) TOLERANCES: PER DART OS, 0.18 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART PIN "D574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART  
7) WEIGHT: 14.33 lbs  
8) CHECK PER TEMPLATE DT8962

DESIGN	<i>MS</i>	<b>DART AEROSPACE LTD</b> HAMMERSBURY, ONTARIO, CANADA REV. B SHEET 3 OF 6
DRAWN	<i>MS</i>	
CHECKED	<i>MS</i>	
MFG. APPR.	<i>MS</i>	
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88574









0.125  
REF

**RELEASED**  
8/2/21 JH

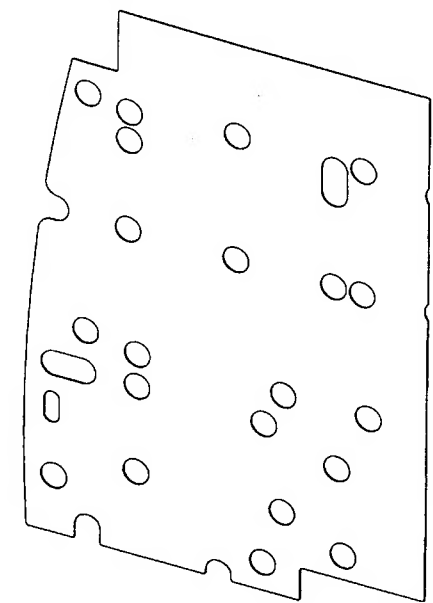
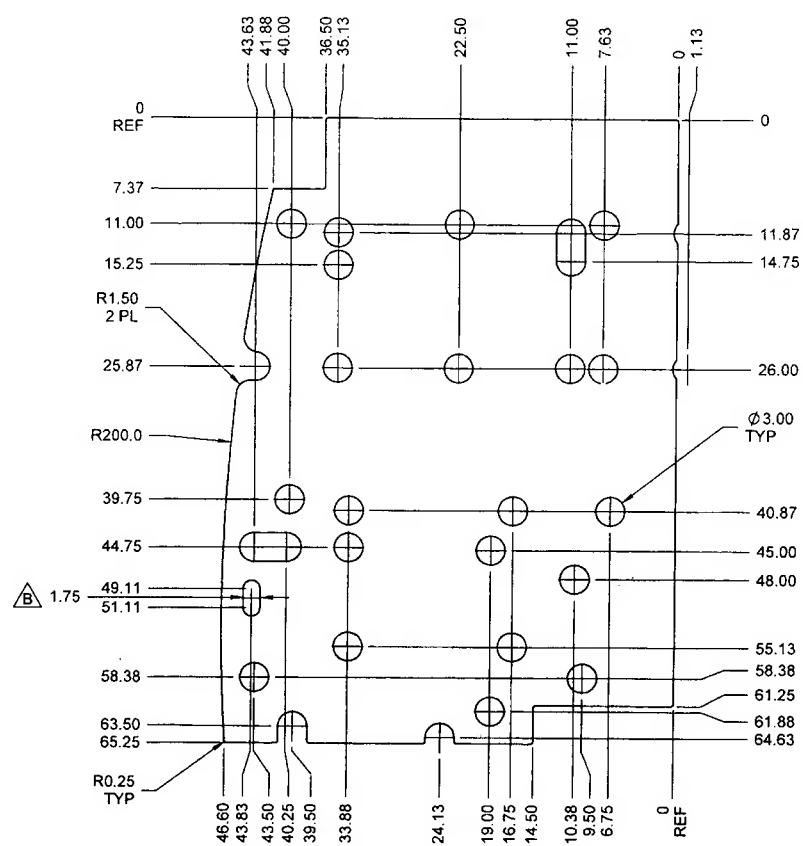
**D3574-4 CABIN FLOOR PROTECTOR**

- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
  - 7) WEIGHT: 14.18 lbs
  - 8) CHECK PER TEMPLATE DT8963

DESIGN		<b>DART AEROSPACE LTD</b>	
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APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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88514



**D3574-5 CABIN FLOOR PROTECTOR**

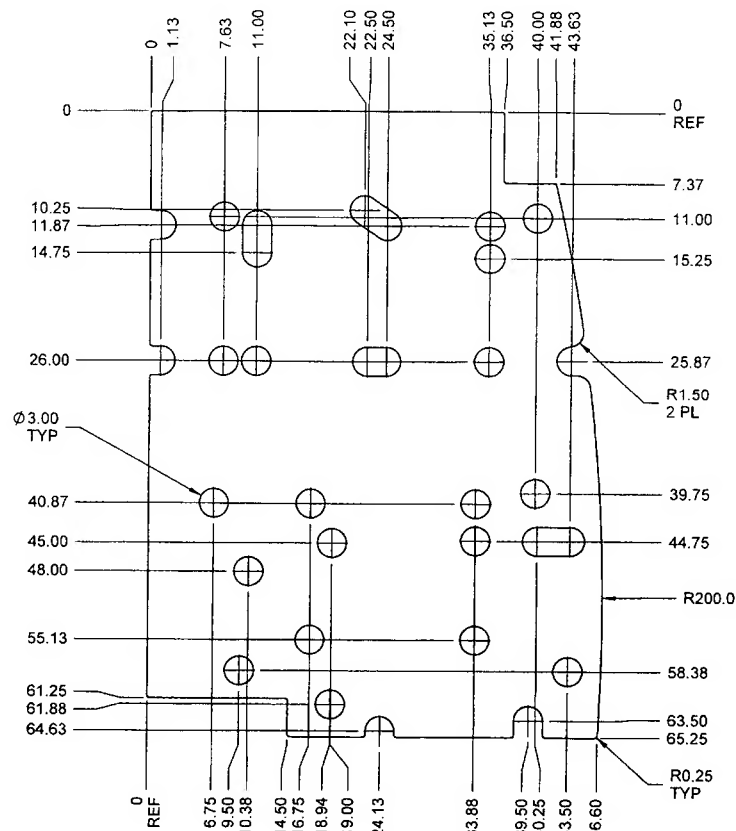
**RELEASED**  
09/04/07 JMB

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>JS</i>	D3574	SHEET 5 OF 6
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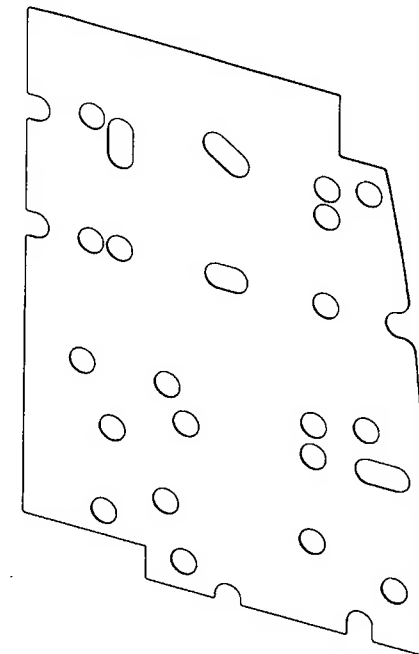


**D3574-6 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.27 lbs
- 8) CHECK PER TEMPLATE DT8965

0.125  
REF



**RELEASED**  
29/02/17

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